

Grooving insert with facettes

A08-100

Grooving inserts with multiple clearance angles are used for deep cuts on round blanks. To cut a groove into the face of a cylindrical blank, the tool must provide pretty good clearance behind the cutting edge in order not to destroy the side wall of inner diameter when it feeds in or out.

The facettes on insert are ground using a rough periphery 1A1 wheel.



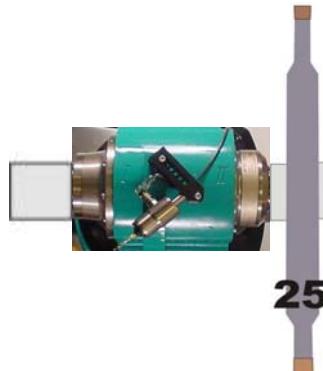
1. Cycletime for Production

Tool specifications					
Length of ground edge: 4x12mm, DXF-profile					
Material CARBIDE					
Operations					
Load	Profile 1	Profile 2	Profile 3	Profile 4	Rotate
Feed [mm/Min]	9000	100	100	100	9000
Power [kW]	1	2	2	2	1
Cutting feed [m/s]		100	100	100	100
Used wheels					
Grinding time [s]	10	20	20	20	10
Total cycle time	1 Min 40 per side				

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

25 | 1A1 Ø300 D64



3. Machine and Software Requirements

Machines: 6 axes CNC grinder: SIRIUS HPM
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 4.3, DXQ

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